

Date: Monday, 07/07/2008 8:36:30 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SLEEVE
Job Number : 40318	
Estimate Number : 13330	
P.O. Number :	Part Number : D37861
This Issue : 07/07/2008 S.O. No. :	Drawing Number : D3786 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 39350	Material :
Written By :	Due Date : 30/07/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08.7.07</u>	
Comment : Est Rev:A 08-05-20 new issue DD verified by:EC Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 TUBE
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Comment: Qty.: 0.1750 f(s)/Unit Total : 0.7001 f(s)

6061T6 TUBE

batch: 19106734RD 08/07/09

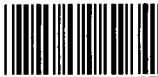
2.0	DOOSAN LATHE	DOOSAN LATHE
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**Comment:** DOOSAN LATHE1- Turn as per Folio FA747 Rev: A & Dwg D3786 Rev: A

2-Deburr per dwg D3786

RD 08/07/09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINERD 08/07/09(10)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKJ.F. 08/07/09(10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RD08-07-09RD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 8:36:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLEEVE

Job Number: 40318

Part Number: D37861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/07/09 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 119

AS 08/07/10 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10 AA

Job Completion



MF 08-07-10

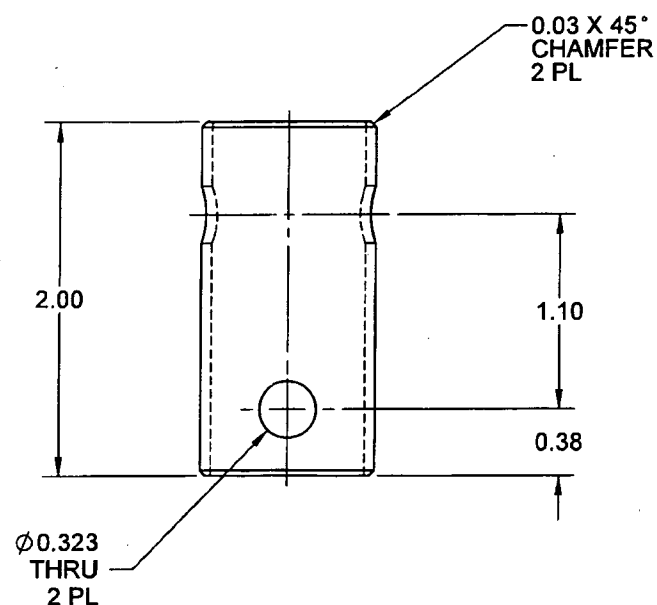
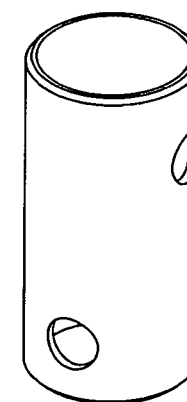
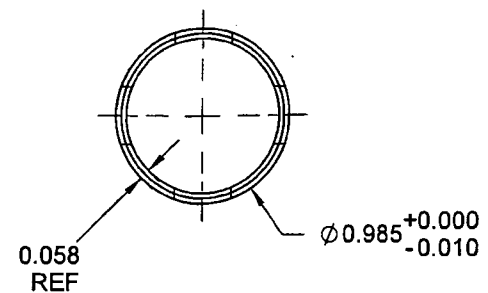
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40318

RELEASED
08.06.16

D3786-1 SLEEVE

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000 X 0.065 WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	HS	D3786	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SLEEVE	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	40318
Description: Crosstube Assembly Sleeve		Part Number:	D3786-1
Inspection Dwg:	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.985	+0 - .010	.980			
	.058	+/- .010	.054			
	.03 x 45°	+/- .03 1/2°	.04 x 45°			
	2.00	+/- .030	2.000			
	1.10	+/- .030	1.101			
	.38	+/- .030	.38			
	.325	+/- .010	.325			
	.323	+ .006 - 0	.325			
SIDE B						

Measured by: <i>CE</i>	Audited by: <i>J.F.</i>	Prototype Approval:	N/A
Date: <i>08/07/09</i>	Date: <i>08/07/09</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	